

Work Order ID 86328

June-27-12 12:52:08 PM

Ship July 4

86328

Page 1

Item ID: D4420-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Top Leg Support Assembly

Start Date: 27/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4420	B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8h45</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>9h15</u>								
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									

52

12/06/27

5

2

SP

12/06/28

5

φ

BL 12-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item Name: Top Leg Support Assembly

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5

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D4420

5x

12/06/12

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

5x

12/06/12

160

Identify as per dwg & Stock Location

0.00

160

Packaging

Memo

0.00

Packaging

5x

12-6-28

W/O:		WORK ORDER CHANGES					
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Required Date: 03/07/2012 Req'd Qty: 5.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/6/29 JH

MF
12-06-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-27-12 12:52:11 PM

Page 1

Work Order ID: 86328

86328

Parent Item: D4420-043

D4420-043

Parent Item Name: Top Leg Support Assembly

Start Date: 27/06/2012

Required Date: 03/07/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM
12.03.05 as per dwg rev.b DD verf:EC

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-3 *D4006-3* Channel		Manufactured	No			110	Each	5.0000	1	5			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				80627				5					
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			140	Each	2,750.000	2	10			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				2750					
				104374				236					
				110398				2514					
MS21059L4 *MS21059L4* Nutplate		Purchased	No			140	Each	58.0000	1	5			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST301				8					
				117887				3					
				119623				5					
				ST302				50					
				121060				50					

7/12/06/27

7/12/06/29

7/12/06/29

7/12/06/29

7/12/09/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

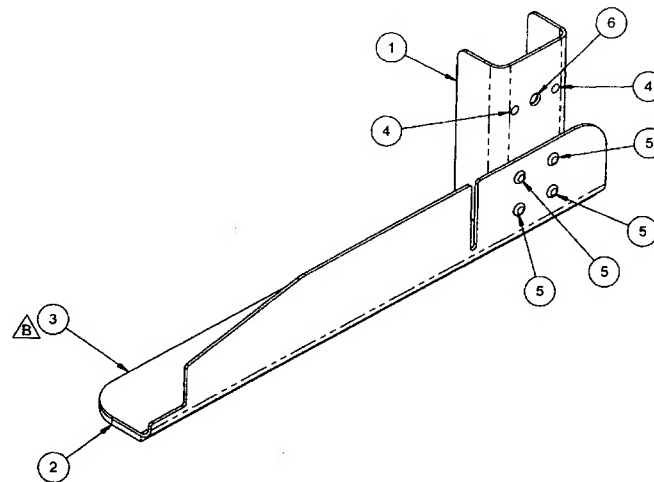
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4420-041	TOP SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	1	D4006-5	FOAM
3	1	D4420-1	ANGLE
4	2	MS20426AD3-4	RIVET
5	4	MS20470AD4-5	RIVET
6	1	MS21059L4	ANCHOR NUT



D4420-041 TOP SUPPORT ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86328 MLJ
12/06/27

RELEASED
2012-03-02
VW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-041" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.38 lbs

B	ADD RELIEFS FOR COMPATIBILITY WITH EUROCOPTER SQUIRREL CHEEK, FINISH WAS "GREY SANDTEX" (4.3.5.8).		MB	12.02.21
A	NEW ISSUE		MB	11.08.22
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO.	REV. B
APPROVED	DE APPR.		D4420	SHEET 1 OF 4
DATE	12.02.21		TITLE	SCALE
			TOP SUPPORT ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

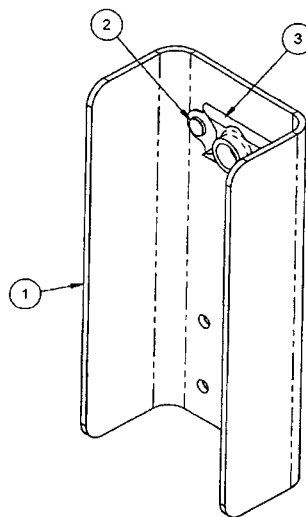
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4420-043	TOP LEG SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	2	MS20426AD3-4	RIVET
3	1	MS21059L4	ANCHOR NUT









D4420-043 TOP LEG SUPPORT ASSY

86328

RELEASED
2012-03-08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3  BEFORE INSTALLATION OF MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-043" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4420	REV. B
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		TOP SUPPORT ASSY	NTS
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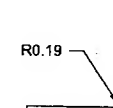
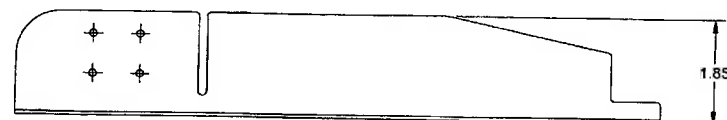
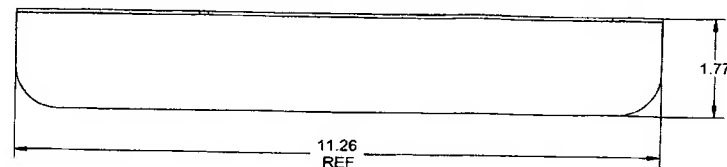
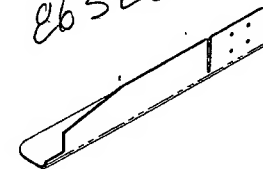
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86328



D4420-1 ANGLE

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM D4420-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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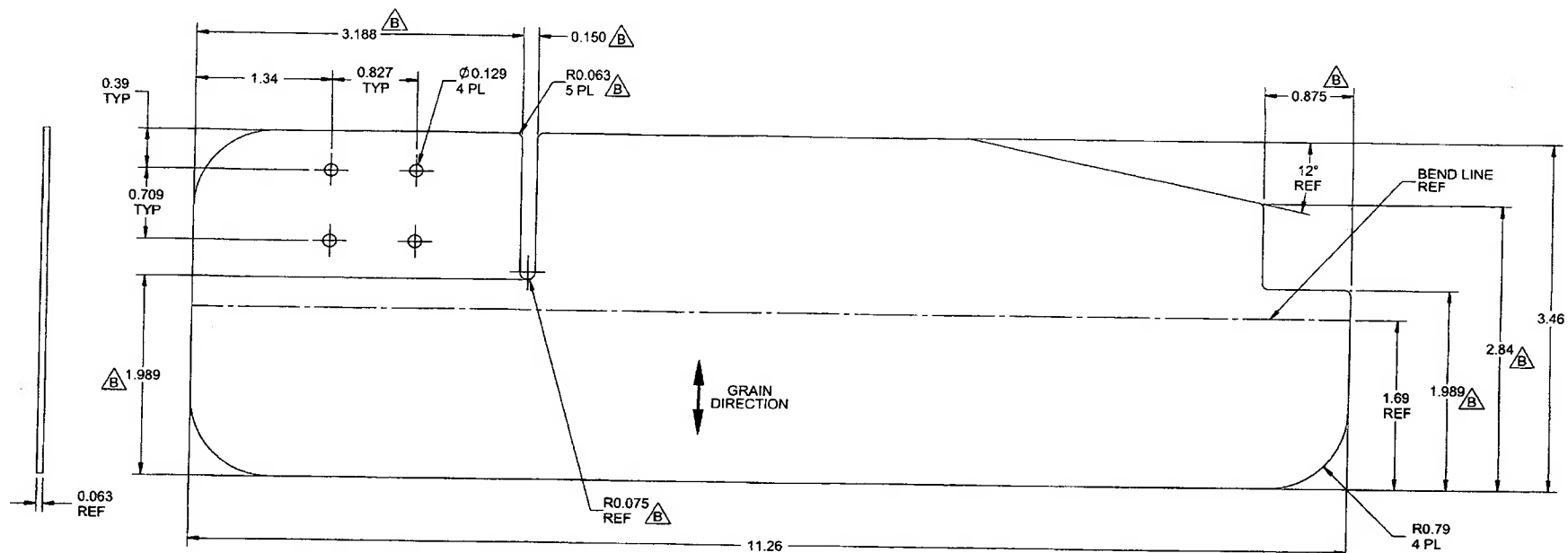
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26328



D4420-1F FLAT PATTERN

RELEASED
2012-03-03

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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